

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007546**Date Inspected:** 28-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xing Xin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** TOWER COMPONENTS**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Gady Rao, was present during the times noted above for observations relative to the work being performed.

Bay 06

SMAW

SMAW welding of weld joint WSD1-DPSA4-10B/B-5, 6. Welder is identified as 037932/066268. ZPMC QCI-CWI is identified as Wu Ming Kai. The welding variables recorded by QC appeared to comply with the WPS- B-T-3312-TC-P5.

Bay 10

FCAW- North Shaft; Lift-2

1) FCAW welding of weld joint NSD1-TL-8C/C-98 located on North Shaft; Lift-2. Welders identified as 052493. ZPMC QCI-CWI is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-Repair.

FCAW- North Shaft; Lift-1

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1)FCAW welding of weld joint NSD1-A166D/J-251 located on North Shaft;Lift-1.Welders identified as 203977. ZPMC QCI-CWI is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-4333-TC-P4-F.

2)FCAW welding of weld joint NSD1-A166C/J-249 located on North Shaft;Lift-1.Welders identified as 053116. ZPMC QCI-CWI is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-4332-TC-P4-F.

3)FCAW welding of welds joint SSD1-FESA4-F/F-41, 42 located on South Tower; Lift-4; Skin-E. Welders identified as 053116/203977. ZPMC QCI-CWI is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the WPS-2321-TC-P5-F.

4) FCAW welding of welds joint SSD1-FESA4-F/F-48, 49 located on South Tower; Lift-4; Skin-E. Welders identified as 057244/054069. ZPMC QCI-CWI is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the WPS-2321-TC-P5-F.

Bay 11

SAW

1)SAW welding of weld joint WSD1-FASA4-2A/E-2A located on West Tower; Lift-4; Skin-A. Welder is identified as 040634. ZPMC QCI-CWI is identified as Cao Cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

SAW-Strut Connection Plates:

2)SAW welding of weld joint SD1-A6002-1-2B, SD1-A6002-1-4A, SD1-A6002-2-2B, SD1-A6002-2-4A, and ED1-A6003-3-2B. Welder is identified as 202756. ZPMC QCI-CWI is identified as Tao Lu Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-4221-B-U3C-S-1.

FCAW

FCAW welding of weld joint ESD1-FASA4-2E/E-53B; 20B, 73B; 4B; 14B, 13B located on East Tower; Lift-4; Skin-A. Welder is identified as 058792/040713/040759/040775. ZPMC QCI-CWI is identified as Zhan Bo. The welding variables recorded by QC appeared to comply with the WPS- B-T-2231-TC-P5-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

In bay-11 FCAW Welding of weld number ESD1-FASA4-2E/E-14B, located on East Tower; Lift-4; Skin-A done by 1.4mm Supercored 71H which the filler wire has been used after 24 hrs. This has been brought to the notice of ZPMC-CWI Mr. Zhan Bo.

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045., who represents the Office of Structural Materials for your project.

Inspected By:	Rao,Gady	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
